

Work Order ID 71617

Thursday, July 07, 2011 7:50:00 AM



Page 1

Item ID: D2620

Accept



Setup Start



Revision ID:

Item Name: Skidtube, 206 Skidtube

120, 11-7-28

Stop



Start Date: 7/7/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan: CZ

Date: 11/07/07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2620

Rev B

100

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft008 2- Cut Fwd end of tube as per Dwg D2620

11-7-28

11-7-28

12

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

12 0

BE 11/08/12

120

Identify as per dwg & Stock Location: LG

0.00



Packaging

Memo

0.00

Packaging

12 0

BE 11/08/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71617

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Item ID: D2620

Accept

Setup Start

Revision ID:

Stop

Item Name: Skidtube, 206 Skidtube

Start Date: 7/7/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/15

11-08-12
(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

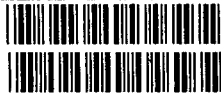
NOTE: Date & initial all entries

Picklist Print

Thursday, July 07, 2011 7:49:58 AM

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Work Order ID: 71617



Parent Item: D2620

Parent Item Name: Skidtube, 206 Skidtube


Start Date: 7/7/2011

Required Date: 7/20/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP D 02.07.26 Change Dwg to rev.B; Updated Location RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-160  Extrusion Round 3" 206		Manufactured	No			100	Each	26.0000	1	10			

Location

LG

43969

59875

Loc Qty

26

19

7

Loc Code

8
4
11-7-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

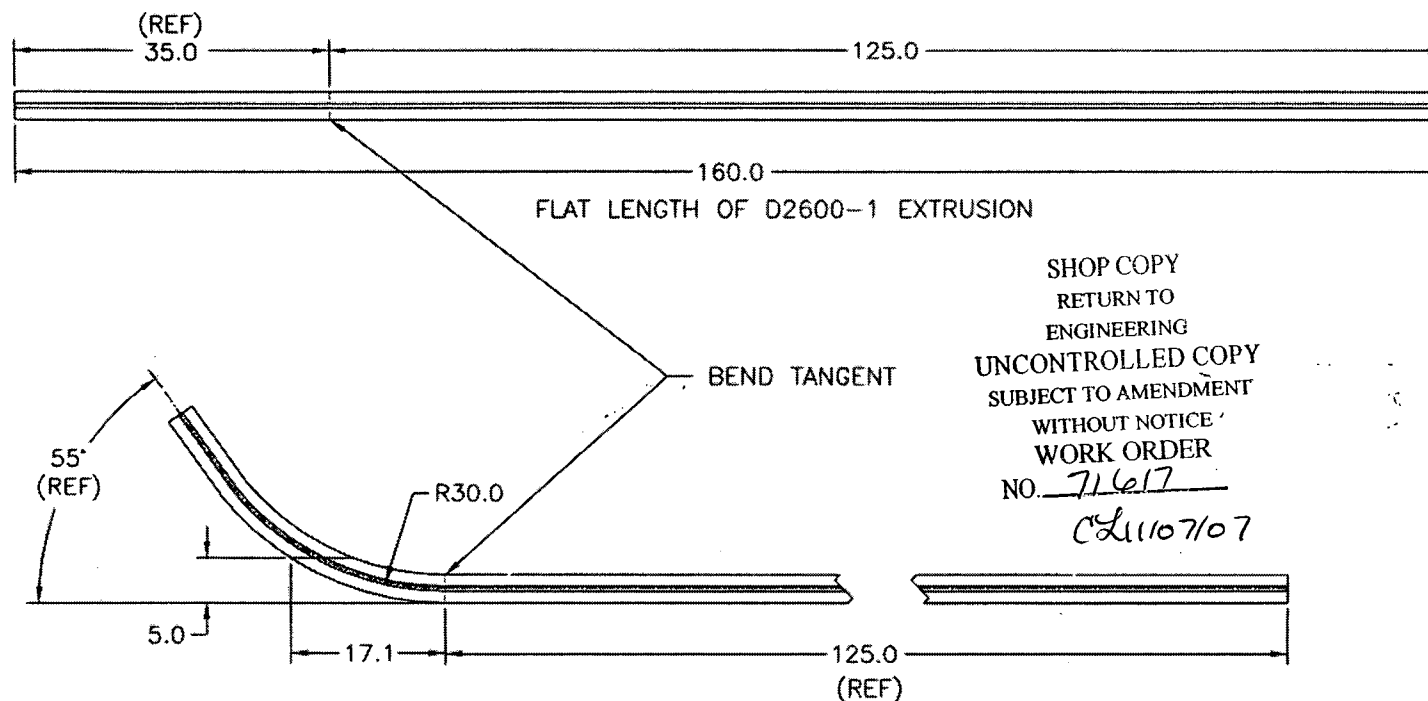
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND. TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND. TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

DART



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE		TITLE
99.09.10		206 SKIDTUBE BENDING CONTROL
A	97.11.07	NEW ISSUE
B	97.09.10	UPDATE FOR IN-HOUSE BENDING
		SCALE
		1:20

RELEASED
49.04.15 DS